



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4095-043
Job Sheet 177816



DAS
21
9-89

Part No: D4095-043

Job Qty: 8 ea

Part Name: Wearplate Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/18/18

Job Tracking No:

Due Date: 5/25/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D SHEETS 1,2,5,6,9 IPP Rev:A new issue DD 10.04.26 verified by:EC IPP REV:B 15.10.29
AUTOMATED WELDING DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	5/25/18	5/25/18	0.00	0.00	Start Up Waterjet		OK 18/05/19
100	Waterjet	6 pcs	5/25/18	5/25/18	0.00	2.16	Waterjet1		OK 18/05/19
110	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC2 Waterjet-3		OK 18/05/19
120	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC8-4		PD 18-05-22
130	Brake NC	6 pcs	5/25/18	5/25/18	0.00	1.34	Brake NC 1		SB DAS 38 9-89
140	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC5		EL
150	Autoweld 1	6 pcs	5/25/18	5/25/18	0.00	6.00	Automated welding		EL
160	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC10		EL
170	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC5		EL
180	HandFinish	6 pcs	5/25/18	5/25/18	0.00	0.29	HandFinish4		AS JUN 30 2018
190	QC	6 pcs	5/25/18	5/25/18	0.00	0.00	QC3		DAS 38 9-89
200	Packaging	6 pcs	5/25/18	5/25/18	0.00	0.00	Packaging3-2	12-002	21 JUL 18-7-10
210	QC21-SA	6 Ea	5/25/18	5/25/18	0.00	0.00	QC21		9-89 JUL 11 2018

Part Op 100 - 1-Cut as per Dwg (D4095-3)

Descriptions: 130 - 1- bend section C-C first

140 - Ensure joggle as per dwg D4095

150 - ***SEE NOTE 10 FOR SURFACE BUILDUP***

180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG 138854

200 - LOCATION : FG002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	13.6500 sf (2.275 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	14	190	0



Container No: S072733



Part: D4095-043

Job No: 177816

Serial No/Batch: S072733

Revision:

Inspector:

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CANADA
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Date: 05/19/18

Part Specifications

Specifications could not be found.

Plex 5/18/18 11:24 AM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	177-816
Description: Wearplate		Part Number:	D4095-043
Inspection Dwg: D4095 Rev: D		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.189	1		V: 0.03	
2.43	+/-0.030	2.43	1		Top	
2.50	+/-0.030	2.50	1			
3.227	+/-0.010	3.224	1			
4.21	+/-0.030	4.21	1			
4.98	+/-0.030	4.98	1			
6.00	+/-0.030	6.00	1			
8.43	+/-0.030	8.43	1			
12.10	+/-0.030	12.10	1			
19.25	+/-0.030	19.25	1			
22.75	+/-0.030	22.75	1			
30.00	+/-0.030	30.00	1			
36.00	+/-0.030	36.00	1			
38.87	+/-0.030	38.87	1			
9.0	+/-0.100	9.0	1			
20.5	+/-0.100	20.5	1			
26.8	+/-0.100	26.8	1			
0.063	+/-0.010	0.059	1			
0.300	+/-0.010	0.305	1			
0.300	+/-0.010	0.303	1			
0.395	+/-0.010	0.398	1			
0.395	+/-0.010	0.396	1			

Measured by:	PC	Checked by:	PD	QC Inspector:	
Date:	18/05/19	Date:	18.05.27	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	16.02.19	New Issue	KJ	
B	17.07.13	Dimensions updated per Dwg Rev D	KJ	